

Date: Friday, 28/11/2008 3:10:38 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TURNING DETAIL FOR D2893-1
Job Number	: 43870		
Estimate Number	: 13234		
P.O. Number	:	Part Number	: DSK078
This Issue	: 28/11/2008	Drawing Number	: DSK078 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: A
Previous Run	: 42596	Material	:
Written By	:	Due Date	: 05/12/2008
Checked & Approved By	: <u>JUD 08.11.28</u>	Qty:	10 Um: Each
Comment	: est rev A. 08.03.13 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6104005	Round Billet, 17-4
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Support

Batch: 1343150

SA 08/12/16

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE
 Turn blank as per Folio FA081

SA 08/12/16

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/12/16

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 08/12/17

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock in Kanban
 Location: _____

SA 08/12/17

(10)

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: TURNING DETAIL FOR D2893-1

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Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/18 *AG*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-12-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43870
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.708	2.708	2.708	2.709	2.709
B	4.946	4.966		4.956	4.959	4.959	4.958	4.959
C	3.064	3.084		3.075	3.075	3.075	3.073	3.075
D	0.718	0.738		.725	.726	.726	.726	.726
E	0.090	0.110		.099	.102	.099	.099	.099
F	2.934	2.954		2.945	2.945	2.945	2.946	2.945
G	2.166	2.186		2.175	2.174	2.175	2.175	2.175
H	3.890	3.910		3.900	3.900	3.900	3.900	3.900
I	0.914	0.934		.924	.924	.924	.924	.924
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.109	0.129		.108	.118	.117	.119	.119
L								
M								
N								
O								
P								

Measured by: SA	Date: 08/12/16
Audited by: [Signature]	Date: 08/12/17
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43870
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

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Lathe Section								
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B	4.946	4.966		4.955	4.955	4.955	4.958	4.961
C	3.064	3.084		3.075	3.075	3.075	3.075	3.075
D	0.718	0.738		.726	.726	.726	.726	.726
E	0.090	0.110		.018	.038	.057	.058	.057
F	2.934	2.954		2.945	2.945	2.945	2.945	2.945
G	2.166	2.186		2.175	2.175	2.175	2.175	2.175
H	3.890	3.910		3.900	3.901	3.901	3.900	3.901
I	0.914	0.934		.924	.924	.924	.924	.924
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.109	0.129		.118	.120	.120	.120	.120
L								
M								
N								
O								
P								

Measured by: SA Date: 08/12/16

Audited by: MK Date: 08/12/16

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	SA

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

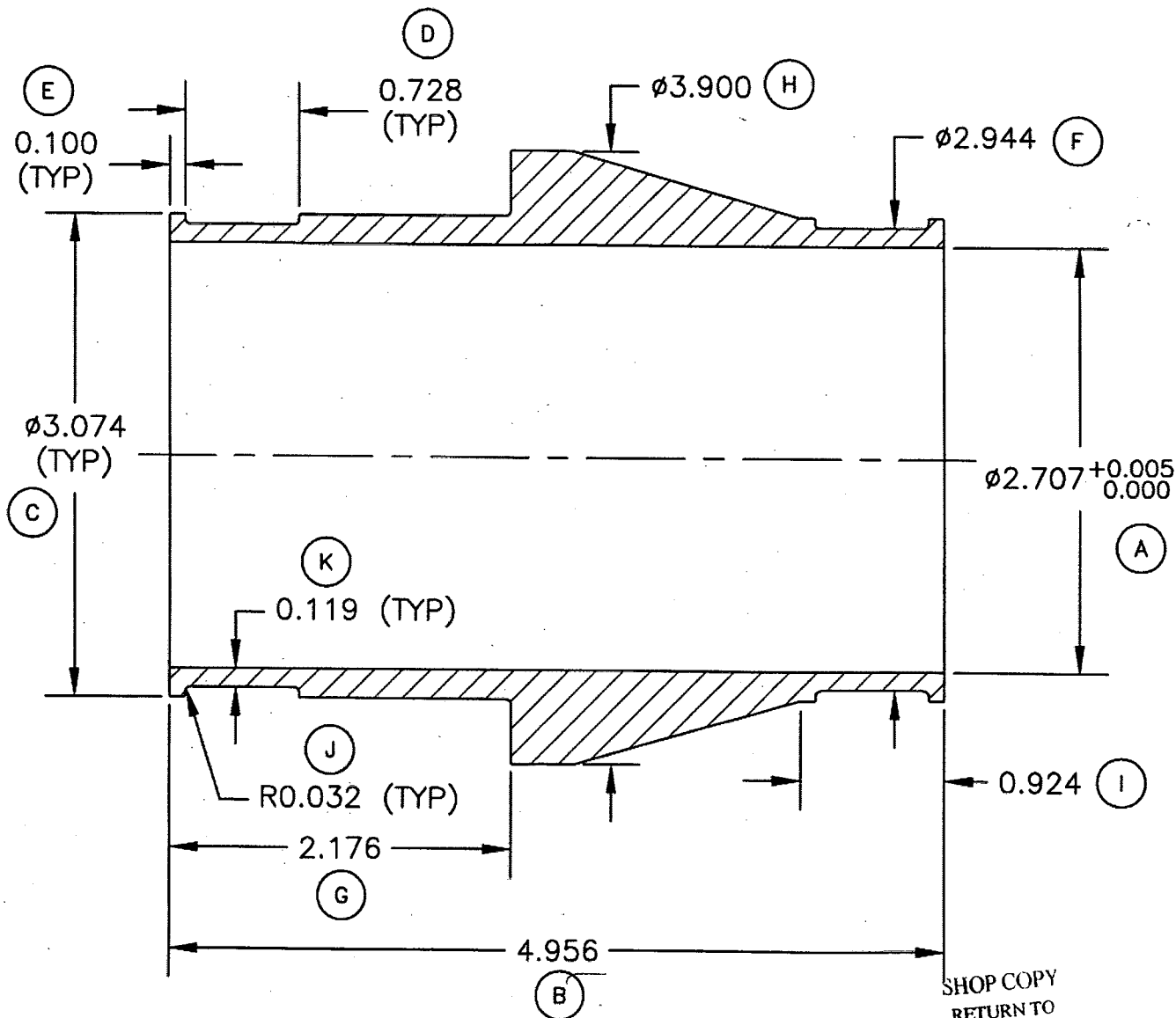
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN KH	DR N	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
#03.07.01



D2893-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43870

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